

Work Order ID 80044

Thursday, February 09, 2012 11:21:05 AM

80044

Page 1

Item ID: D4055-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Aft End

Start Date: 2/10/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *2-02-09* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4055

Prog rev: *B*

Dwg rev: *B*

6061 . 063

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

B12-2-9

(4)

B12-2-9

8/12/11

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

SB 12/03/07

(4)

Brake NC

140

QC6- Inspect dimensions to drawing

0.00

140

QC

Memo

0.00

5/12/03/08

(74)

Quality Control

141

Chemical Conversion Coat per QSI005 4.1

0.00

141

HandFinish

Memo

0.00

Hand Finishing

4X Ø M. / 12/03/08

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Page 3

Item ID:- D4055-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Tank Aft End

Stop ***NS2***

Start Date: 2/10/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

142

QC3- Inspect Part Finish

0.00

142

QC

Memo

0.00

Quality Control

4 6 12/03/08

150

Identify as per dwg & Stock Location: WA 0.00

150

Packaging

Memo

0.00

Packaging

STEP CELL

12-03-08

4 6

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

0.00

Quality Control

MCJ 12/03/08

12-03-8

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Picklist Print

Thursday, February 09, 2012 11:21:05 AM

Page 1

Work Order ID: 80044

Parent Item: D4055-3

Parent Item Name: Tank Aft End

Start Date: 2/10/2012

Required Date: 2/24/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM
house DD verf:EC
IPP rev:B 10.11.23 now made in

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	273.0696	1.5143	6.376			

182-2-9

Location	Loc Qty	Loc Code
MAT021	273.0695684	
113608	0	
116308	11.4555684	
117285	75.414	
119331	49.2	
119802	25.5	
120218	111.5	

120218

4

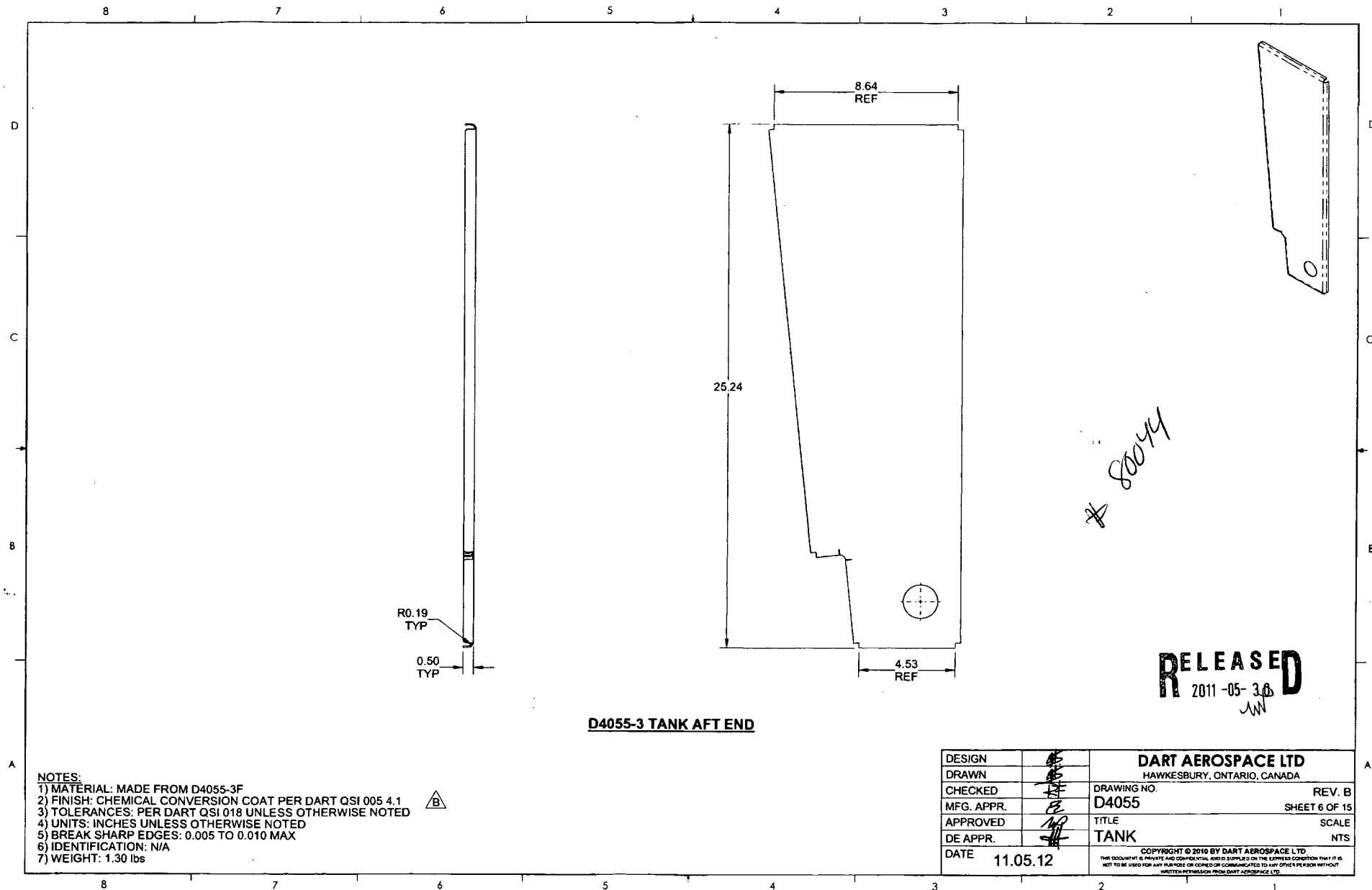
Dart Aerospace Ltd

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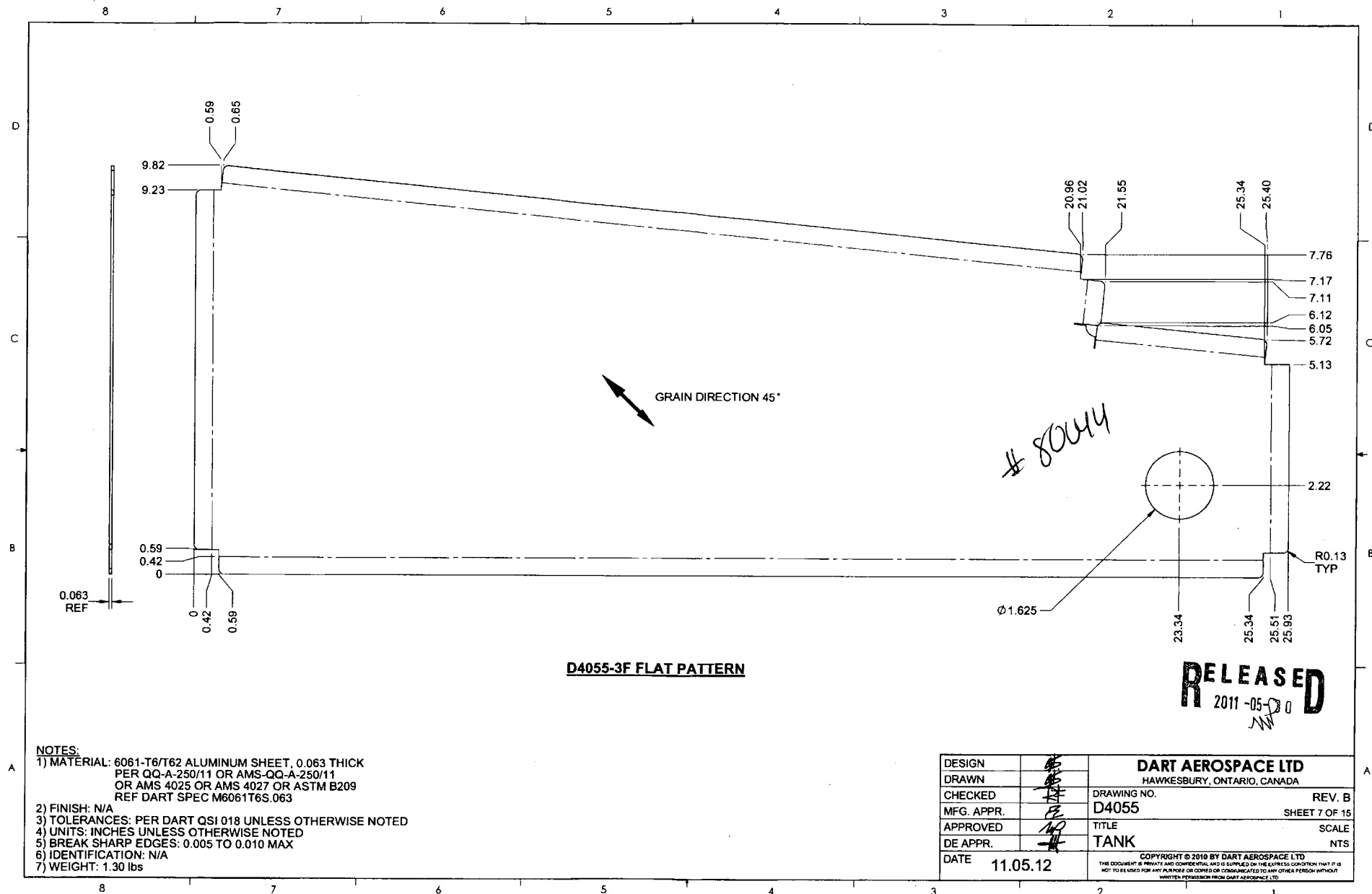
Dart Aerospace Ltd

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NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 7 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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DART AEROSPACE LTD		Work Order: 80014
Description: Tank Aft End		Part Number: D4055-3
Inspection Dwg: D4055	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.42	+/-0.030	.422	✓		✓ 1B62	
0.59	+/-0.030	.593	✓		✓	
9.23	+/-0.030	9.23	✓		✓	
9.82	+/-0.030	9.82	✓		✓	
0.59	+/-0.030	.593	✓		✓	
0.65	+/-0.030	.653	✓		✓	
23.34	+/-0.030	23.34	✓		T B01	
25.34	+/-0.030	25.34	✓		T	
25.51	+/-0.030	25.51	✓		T	
25.93	+/-0.030	25.93	✓		T	
2.22	+/-0.030	2.222	✓		✓	
5.13	+/-0.030	5.136	✓		✓	
5.72	+/-0.030	5.724	✓		✓	
6.05	+/-0.030	6.051	✓		✓	
6.12	+/-0.030	6.121	✓		✓	
7.11	+/-0.030	7.11	✓		✓	
7.17	+/-0.030	7.17	✓		✓	
7.76	+/-0.030	7.76	✓		✓	
20.96	+/-0.030	20.96	✓		T	
21.02	+/-0.030	21.02	✓		T	
21.55	+/-0.030	21.55	✓		T	
25.34	+/-0.030	25.34	✓		T	
25.40	+/-0.030	25.40	✓		T	
0.063	+/-0.010	.063	✓		✓	

Measured by: TB	Audited by: J	Preliminary Approval:
Date: 12-2-9	Date: 12/02/11	Date:

Rev	Date	Change	Revised by	Approved
A	11.01.18	New Issue	KJ	
B	11.08.22	Dwg Rev updated	KJ	

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